

Amendments to the Claims:

The listing of claims will replace all prior versions, and listings, of claims in the application. Kindly enter the English translation of annexes to the International Preliminary Examination Report, and amend the claims as follows.

Listing of Claims:

1-7. (Canceled).

8. (New) A tube piece comprising at least one bend zone, and two outlet zones adjoining the at least one bend zone on both sides, each of the outlet zones having an end side for application of pushing rams of an internal high-pressure tool including a die with a recess forming a production cross section, wherein the bend zone has a different cross-sectional shape from the outlet zones with an approximately identical flow cross section, wherein an axis of symmetry of the bend zone extends in a bending plane, wherein, in a region of the bending plane, a degree of expansion, as a ratio of a diameter of the blank in the bending plane to a diameter of the component in the bending plane, is between 0.9 and 1, and wherein a degree of expansion in a region normal to the bending plane is between 0.3 and 1.

9. (New) A tube piece as claimed in claim 8, wherein multiple bend zones and multiple bending planes are provided.

10. (New) The tube piece as claimed in claim 8, wherein a transition of the cross-sectional shape from each outlet zone to the bend zone extends continuously.

11. (New) The tube piece as claimed in claim 8, wherein the cross-sectional shape of at least one of the bend zone and the outlet zones is of round, oval, rectangular or polygonal design.

12. (New) The tube piece as claimed in claim 8, wherein the degree of expansion is between 0.6 and 0.8.

13. (New) The tube piece as claimed in claim 9, wherein a transition of the cross-sectional shape from each outlet zone to the bend zone extends continuously.

14. (New) The tube piece as claimed in claim 9, wherein the cross-sectional shape of at least one of the bend zone and the outlet zones is of round, oval, rectangular or polygonal design.

15. (New) The tube piece as claimed in claim 10, wherein the cross-sectional shape of at least one of the bend zone and the outlet zones is of round, oval, rectangular or polygonal design.

16. (New) An internal high-pressure tool for manufacturing a tube piece comprising a die with a recess forming a production cross section of a tube bend, the recess having at least one bend zone and two outlet zones adjoining the at

least one bend zone on both sides, wherein the recess of the die has a different cross-sectional shape from the outlet zones with an identical cross-sectional area forming the production cross section, wherein an axis of symmetry of the bend zone extends in a bending plane, wherein, in a region of the bending plane, a degree of expansion, as a ratio of a diameter of the blank in the bending plane to a diameter of the component in the bending plane, is between 0.9 and 1, and wherein a degree of expansion in a region normal to the bending plane is between 0.3 and 1.

17. (New) The tool as claimed in claim 16, wherein multiple bend zones and multiple bending planes are provided.

18. (New) The tool as claimed in claim 16, wherein a transition of the cross-sectional shape from each outlet zone to the bend zone extends continuously.

19. (New) The tool as claimed in claim 16, wherein the cross-sectional shape of at least one of the bend zone and the outlet zones is of round, oval, rectangular or polygonal design.

20. (New) The tool as claimed in claim 16, wherein the degree of expansion is between 0.6 and 0.8.

21. (New) The tool as claimed in claim 17, wherein a transition of the cross-sectional shape from each outlet zone to the bend zone extends continuously.

22. (New) The tool as claimed in claim 17, wherein the cross-sectional shape of at least one of the bend zone and the outlet zones is of round, oval, rectangular or polygonal design.

23. (New) The tool as claimed in claim 18, wherein the cross-sectional shape of at least one of the bend zone and the outlet zones is of round, oval, rectangular or polygonal design.

24. (New) A method for manufacturing a tube piece comprising placing a tube piece blank with a diameter A into a recess of a die of an internal high-pressure tool so as to be acted on by pushing rams, forming the tube piece blank to a desired diameter B in outlet zone regions, forming the tube piece blank to a desired diameter C in a direction parallel to a bending plane in the region of a bend zone, forming the tube piece blank to a desired diameter D in the direction at right angles to the bending plane in the region of the bend zone, and setting a degree of expansion as the ratio of the tube piece blank diameter A to the desired tube piece blank diameter C between 0.9 and 1.

25. (New) The method as claimed in claim 24, wherein the degree of expansion as a ratio of A to D is set between 0.3 and 1.

26. (New) The method as claimed in claim 25, wherein the degree of expansion is set between 0.6 and 0.8.